

Work Order ID 57821

April 16, 2010 10:46:58 AM



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Item ID: D3917-1

Revision ID:

Item Name: Washer

Start Date: 16/04/2010 Start Qty: 30.00

Required Date: 29/04/2010 Req'd Qty: 30.00

Reference: *10.01.16*

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3917

a

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER FOLIO FA873 & DWG

FOLIO REV: AA

DWG REV: A

0.00

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

SL 10/04/18

SL 10/04/18

40

Pto
LAST FILE

Lean is...

- Promote customer-orientation rather than resource-orientation (produce for sales not for stock).
- A highly evolved method of managing an organization to improve the productivity, efficiency and quality of its products or services.
- Transforms how the company operates and how employees think about their work. Don't work harder but smarter by transferring your energy from the NVA to the VA activities.
- Has no end (there is no "done").

WORK ORDER CHANGES

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3917-1 PAR #: Fault Category: Machining NCR: Yes No DQA: Date: 10/04/20
 Resolution: Accepted Disposition: use as is QA: N/C Closed: Date: 10/05/12

NCR: 57821		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/20	#110 + 170	when who was being close to Q&Q 21 it was notice that the FAI was near filled out by either employees (Q&Q or Q&C dir/off/eng)		→ Fill out FAI sheet correctly → 2 w/o's with the same P/W were being worked on & the FAI was supposed to be attached, but forgotten. Parts were measured & recorded on this FAI.	 10.5.12	 10/05/12.		 10/04/20
		R.L. Lack of Attention		→ Record on Job training sheet the importance of ensuring that every thing is filled out correctly	N/A	 10/05/12		 10/04/20

NOTE: Date & initial all entries

Dart Aerospace Ltd
W/O:
DATE:

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Accept

**Setup Start**

Stop

Cust Item ID:

Customer:

Run Start

Date:

Tooling:

Date:


Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				(40)			
130 	Identify as per dwg & Stock Location: 065	0.00							
Packaging Packaging	Memo	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/05/12 
MF 10-4-20

Lean principle

To be able to produce exactly:

- **what is required**
- **when it is required**
- **the quantity required**

by the next step in the process.

Once a job started, it should ideally never stop

Picklist Print

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Work Order ID: 57821

Parent Item: D3917-1

Parent Item Name: Washer

Start Date: 16/04/2010

Required Date: 29/04/2010

Comments: IPP REV:A NEW ISSUE 09-11-26 JLM VERIFIED BY:DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELNRN0.750		Purchased	No			100	f	66.1700	0.6316			



Delrin Round Bar 0.75"

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT050

66.17

112418

34.17

112480

32

700 SK 10/04/19

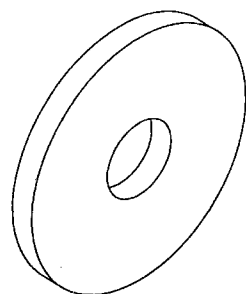


Lean Is...

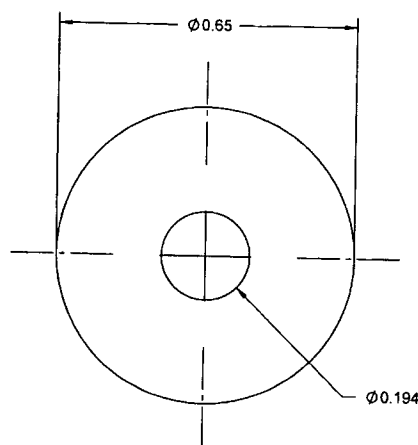
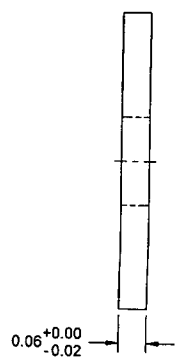
- “LEAN IS – from an operations perspective... a system that cuts costs & inventories rapidly to free cash, which is critical in a slow economy. It also supports growth by improving productivity and quality, reducing lead times and freeing huge amounts of resources.
- Lean aims at reducing (if not eliminating) none value added activities in business processes.
- It's not a project.

Value stream mapping

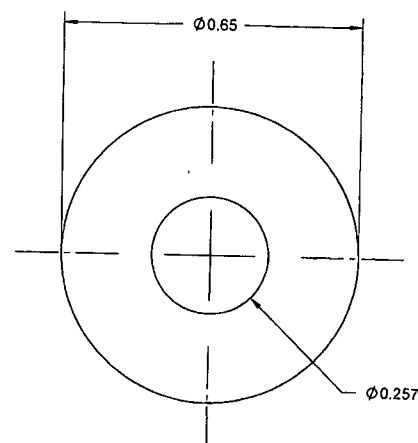
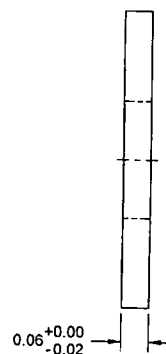
- Value stream mapping is **the best way to identify where the high payoff** opportunities are, yet value stream mapping is the lean tool most likely to **not be used by** companies doing pretend lean!



ISO VIEW



D3917-1 WASHER



D3917-3 WASHER

RELEASED
2010-02-16

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, COLOR BLACK
REF DART SPEC M-DELRIN-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QS1018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: < 0.01 lbs

A		NEW ISSUE		JPH	10.01.29
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AJS			SHEET 1 OF 1	
CHECKED		DRAWING NO.		D3917	
MFG. APPR.		TITLE		WASHER (350 BASKET)	
APPROVED		DATE		10.01.29	
DE APPR.		SCALE		NTS	
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Lean Is...

“LEAN IS... A mindset, or way of thinking

- A commitment to achieve a totally waste-free operation focused on the customer's success
- Achieved by simplifying and continuously improving all processes and relationships in an environment of trust, respect and full employee involvement
- It is about people, simplicity, flow, visibility, partnerships and true value as perceived by the customer.”